Single Bridge Installation manual

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1.Checking installation condition before installing machine

(1) Installation condition.

1) Temperature.
When machine work : 0。~40。C (32。~104。F)
When machine doesn't work (maintenance) : －25。~55。C (－13。~131。F)

2) Humidity
Humidity : 45~85%

3) Surrounding condition
Please close window and entrance door to prevent sun light and moisture and dust from coming to machine.

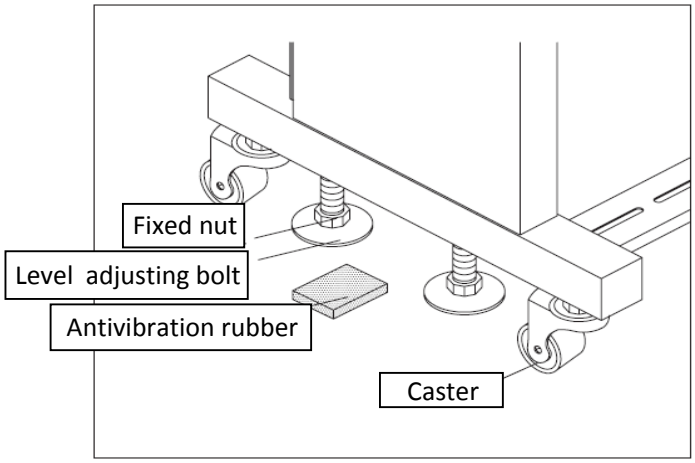
4) Installation place.
Please install machine on flat ground as well as ground is concrete structure which is enough to bear machine weight without bumpy.

5) Main power : 1Ø 100~240V 50~60Hz ±10%

2. Machine installation and checking condition of external appearance

(1) Fixing a machine.

In case using exclusive stand,
fixing machine on stand table.
4 antivibration rubbers are placed under under level adjusting bolt and adjust level adjust bolt until caster is over ground.
Left and right and front, back of machine should level off as using level gauge.



(2) Checking X-Frame movement whether there is any interruption or not.

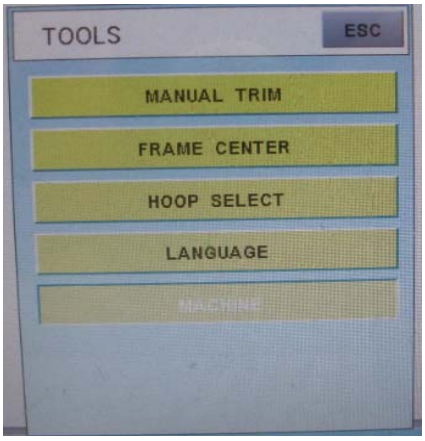
1) Before turn on the machine, checking X-Frame movement whether theris is any interruption or not (limit sensor, sensor bracket, dust, etc) If there is any interruption, remove obstacle for moving X-Fr

3. Machine motion TEST and Running Test.

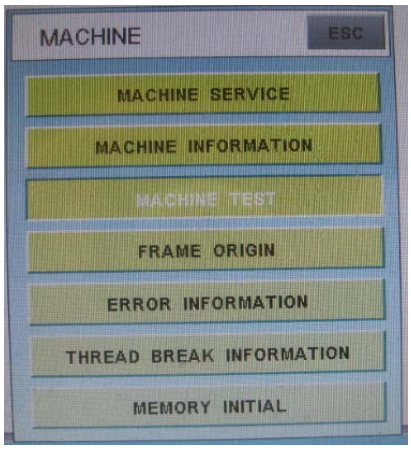
1) After fixing machine, perform machine motion test.

If there is any problem, connect to SWF agent for solving problem.

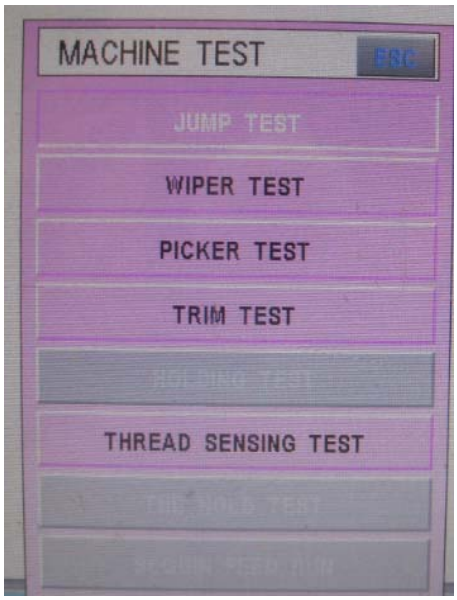
TOOLS -> MACHINE



MACHINE TEST



TEST MENU



Perform each test function whether machine works normally or not.

(JUMP TEST, WIPER TEST, PICKER TEST, TRIM TEST, THREAD SENSING TEST)

4. Checking and adjusting needle position.

* Checking needle position : First, change a color as placing that middle needle bar is on center. An

checking needle position as downing middle needle

* In case needle position is not normal, please adju

1) Degree of Main shaft is between 130 and 140°

2)Release 3 Head rail screws

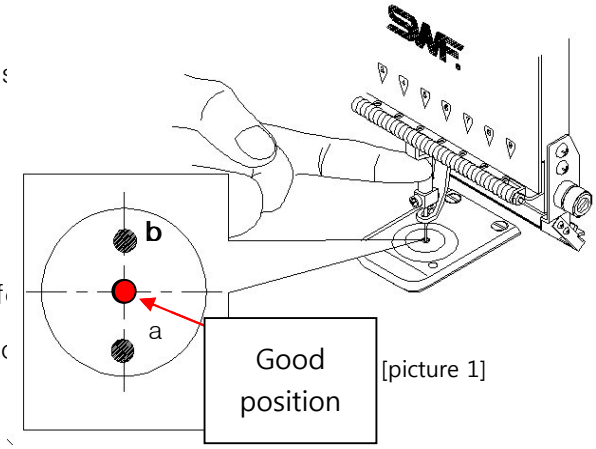
to use 3mm T-wrench and "-" driver

When disassemble middle head rail screw, presser f

of 3,4 needle bar is prevented. So, down presser foo

of 3,4 needle bar, and release screw.

Reference to [Picture-2]



[picture 1]

①In case head rail gauge exist

a) Remove head rail gauge.

②In case head rail gauge doesn't exist.

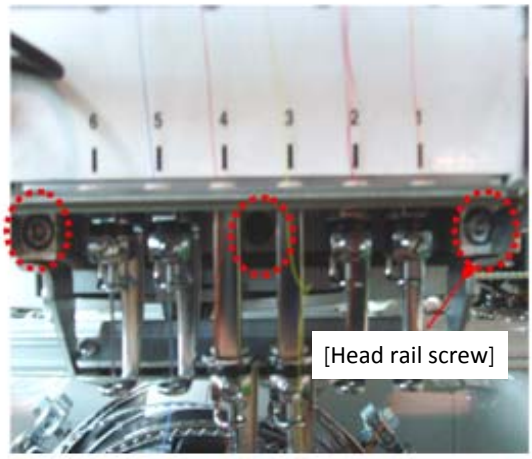
a) Replace head rail to use 3mm T-wrench and "-" driver.

* The sort of thickness of head rail

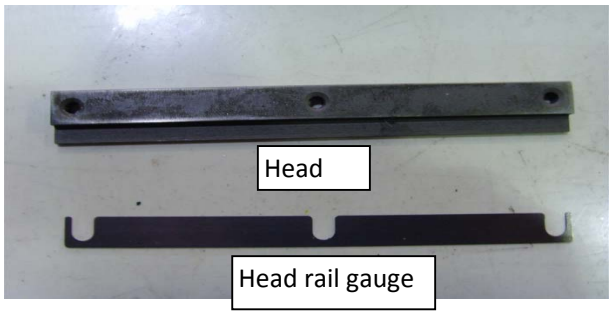
Standard:5.4mm

(-)gauge[special gauge]:5.3mm,5.2mm

3) Assemble head rail screws.



[picture 2]

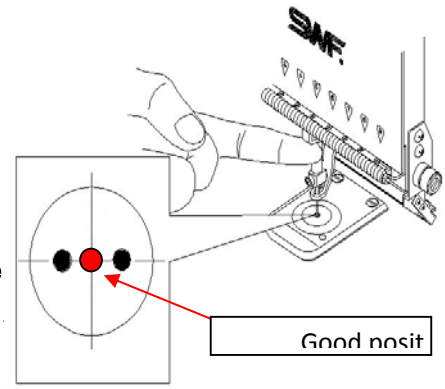


How to adjust needle position, in case left and right of needle

* Checking needle position : First, change a color as placing

checking needle position as downing middle needle bar.

* Reference to [Picture-3]



[picture 3]

2) Disassemble color-change-cover After Disasemble Color-change-Cover-trust-bolt(4x6)

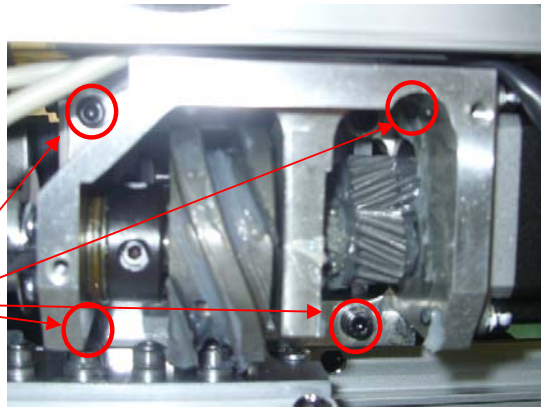
3) Open the color-change-set-fixing-bolt(4unit)

and adjust needle position as moving the middle

(Re-check the condition after assemble the

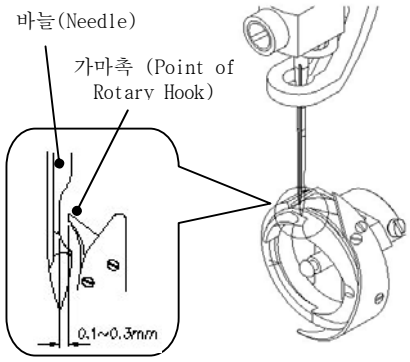
Caution - If needle position is not correct, it will be caused needle damage. So you have to adjust needle position correctly with head rail gauge of proper thickness.

color change set fixing bolt

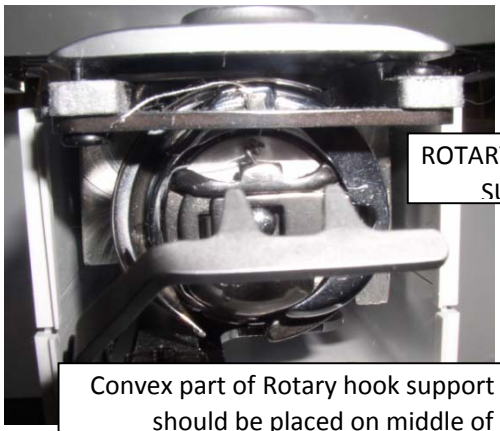


5. Checking and adjusting Hook setting condition.

(1) Fixing main shaft to 201 degree, and check a gap between tip of hook and needle.
(In case gap is over 0.1~0.3mm, reset distance of hook and needle to use "-" driver.
How to reset : Release 2 of 3 hook fixing screws at middle needle bar position.(at 135, 75 de
If tip positon of hook is not good or gap between tip of hook and needle is not good, you neec
After reset them, checking distance between tip of hook and needle at 1,6 needle bar.
If needle position and gap is good, fasten two hook fixing screws.



Tip of hook should be placed on back side of needle, and distance is 0.1~0.3mm



Convex part of Rotary hook support should be placed on middle of needle, and distance is 0.5~0.7mm

(2) Checking and adjusting position of ROTARY HOOK SUPPORT.

Convex part of Rotary hook support should be placed on middle of needle, and distance is 0.5~0.7mm from hook. If distance is not good, you need to adjust distance as disassembling fixing

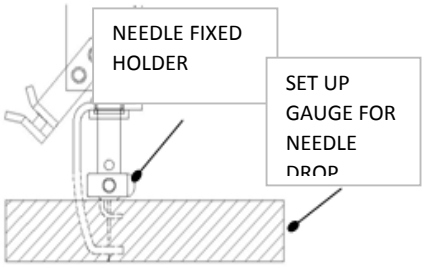
6. Checking and adjusting Upper and bottom dead point of needle bar.

* Check a gap between Jig and Upper dead point after inserting Jig. If there is a gap or Jig is not inserted, you need to reset Upper dead point.
Reference to 「Picture-4」

1) Upper dead point setting.

①Main shaft 201°

②Using Bottom dead point jig, please fasten a "needle bar holder screw" after pushing down needle bar fixing holder.
After fastening a needle bar holder screw, please check whether Jig move smoothly between bed and "Needle fixed holder".



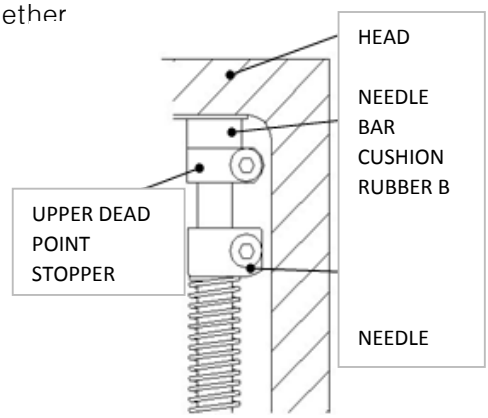
[picture 4]

Caution) when fastening needle bar fixing screws, pervent needle hare from deformation

2) bottom dead point

①Main shaft 0°

②"Upper damd point stopper" is pushed to "Needle bar cushion rubber B", fasten a screw.



Reference to [Picture-5]

[picture 5]

3) After changing needle bar(color) with avoiding reciprocator,
you check needle bar whether it works smoothly or not.

4) Assemble head face plate

[picture 6]

7. Checking and adjusting height of Presser foot.

* How to se

1) Disassemble Head Face Plate to use "+" driver.

2) Release presser foot holder screw a little.

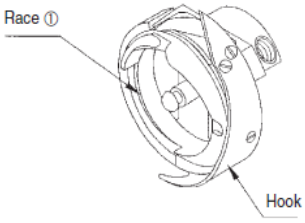
3) When you adjust height of presser foot, degree of main is 180 degree.

4) Fasten a presser foot holder screw after adjusting height of persser foot with presser foot height gauge.
Reference to [Picture-6]

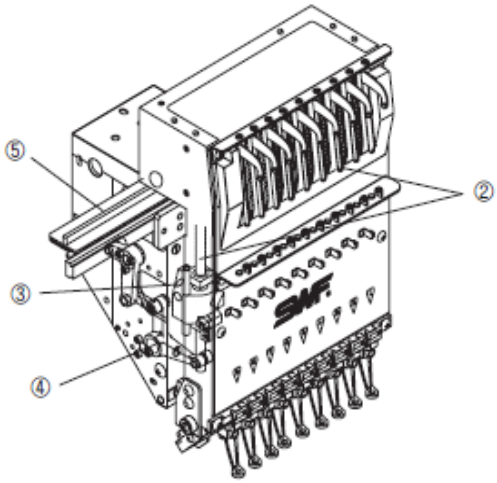
※ Presser foot height is adjustable,it depends on fabric
Standard :0.5mm

8. TEST work with mater

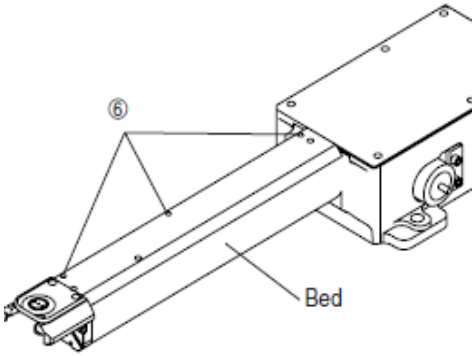
(1) Lubrication



[picture 7]



[picture 8]



[picture 9]

[Picture 7~9] You need to test machine's position after putting oil (user manual 9.3) Refer to OIL

(2) Runing Test

① Test runing 600rpm with design.

② Check if lower shaft bearing bushing has departed, drive is overheated, and noise from fram

③ Check the vibration of machine.

④ After Running Test, check the status of machine.

(3) embroidery test

※ Checking a machine condition as testing with fabric and thread of customer, test design.
Checking Dadami condition and trimming, thread break.

※ Test a design of customer.

※ When testing to work, teach customer operation and maintenance of machine.

E-COMPACT Report

Country		Model	
Agent		Serial No.	
Company		Version Date	
Date		Technician	

Order	List
1	**Check List of Environment before instalation**
	Status of machine before it arrived at your company ☐ Start from Wood box Opening ☐ When you arrived,machine was moving to inside of factory ☐ Arrived during installation ☐ Arrived during assembly (which setp:) ☐ After whole procudre ☐ etc, ( ) (1) Temperature/ humidity,ambience ☐ good ☐ bad (2) The number of layers : (3) Material of bottom : (4) Levelness of floor ☐ good ☐ bad (5) Speculation of voltage : (6) Input 1P (V) Voltage : 3P (R↔S : V) (R↔T : V) (S↔T : V)
2	**Check List for installation and exterior**
	(1) Safe Arrival - When arrived, check the levelness of of machine ☐ good ☐ bad - Adjust levelness with Bolt and check (if it is not correct at first) ☐ good ☐ bad (2) Check status of frame and debris - Check status of frame at first site ☐ good ☐ bad - Check debris or not ☐ good ☐ bad
3	**Check list for movement TEST and Running TEST**
	After safe arrival,test movement of machine (1) JUMP TEST ☐ good ☐ bad (2) WIPER TEST ☐ good ☐ bad (3) PICKER TEST ☐ good ☐ bad (4) TRIM TEST ☐ good ☐ bad (5) THREAD SENSING TEST ☐ good ☐ bad

4 Check B.D.P status and adjusting

① Before

NEEDLE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
UPPERDEAD POINT															
NEEDLE POINT															

② After

NEEDLE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
UPPERDEAD POINT															
NEEDLE POINT															

※ When insert guage,record it.

5 Check list for Hook timimg and adjusting(good:O, bad:X)

Hook timing 201°, No gapss with Needle, more than 0.3mm,reset it.

① Before ☐ good ☐ bad

② After ☐ good ☐ bad

6 Check list for checking the Pressor Foot and set (good:O, bad:X)

General Head – If needle bar(180°) is out of 1.2mm from Upper Face,reset it.

① Before ☐ good ☐ bad

② After ☐ good ☐ bad

※ Able to adjust ,depends on product (delivery Data : 1.2mm, Thin Fabric:0.7mm이하, Thick Fabric:

7 Presser foot height check and setting

If all needles on 180 degree don't have 0.5mm height from needle plate, adjust it again.

① Before ☐ good ☐ bad

② After ☐ good ☐ bad

※ It can have different height setting depending on fabrics

Basic Data : 0.5mm

8 Sewing TEST.

※ Test with thread and fabrick from your company and check Status of machine

Check Nomalization status,cutting thread

(If the Agent didn't prepare desing,test it with workplace sewing design and check)

※ When test Sewing, check the cutting thread, work timek,missing the first needle and then report

Attach the Sample and Design to report.

※When Sewing TEST,train the worker and manager that how to operate/maintain the machine.